

Date: Tuesday, 07/04/2009 3:21:42 PM
 User: Melanie Fauteux

Process Sheet

| | |
|-----------------------------------------------------------------|------------------------------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY |
| Job Number : 47053 | |
| Estimate Number : 13434 | |
| P.O. Number : | Part Number : PB674300117 GN |
| This Issue : 07/04/2009 S.O. No. : | Drawing Number : B6743001 P.7 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 07/04/2009 Type : LARGE FAB ASSY | Drawing Revision : B1 |
| Previous Run : 45040 | Material : |
| Written By : | Due Date : 14/04/2009 Qty: 1 Um: Each |
| Checked & Approved By : <u>ME 09-04-08</u> | |
| Comment : Est Rev:A 08-06-26 new issue DD verified by:ec | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------------|------------|
| 1.0 | PB6743001259 | Inner Tube |
|-----|--------------|------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube

batch: B43069 = 1x

SP 09.04.20

| | | |
|-----|--------------|--------------------|
| 2.0 | PB6743001249 | Inner Tube Bushing |
|-----|--------------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube Bushing

batch: B44984 = 1x

SP 09.04.20

| | | |
|-----|--------------|--------|
| 3.0 | PB6743001253 | Gusset |
|-----|--------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: B44983 = 1x

SP 09.04.20

| | | |
|-----|--------------|--------|
| 4.0 | PB6743001254 | Gusset |
|-----|--------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: B44982 = 1x

SP 09.04.20

| | | |
|-----|-------------|---------------|
| 5.0 | PB674300171 | PB67-43001-71 |
|-----|-------------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-71

batch: B41512 = 1x

SP 09.04.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:43 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47053

Part Number: PB674300117

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|------------------------------|
| 6.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

SP 09-04-20 (X)

| | | |
|-----|-----|---------------------------|
| 7.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

PD 09-04-21 (U)

| | | |
|-----|-----|------------------------------|
| 8.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

Sorley 21 @

| | | |
|-----|----------|----------------|
| 9.0 | MS124780 | HELICAL INSERT |
|-----|----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
HELICAL INSERT m111064

FD 09-05-05

| | | |
|------|-------------|-------------------------------|
| 10.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- install helicol insert as per dwg

FD 09-05-05

| | | |
|------|-----|------------------------------|
| 11.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

Sorley 05 @

| | | |
|------|-----------------|----------------------------|
| 12.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

u / K

| | | |
|------|----------------|----------------|
| 13.0 | POWDER COATING | POWDER COATING |
|------|----------------|----------------|



Comment: POWDER COATING

- 1- MASK TUBE FROM BASE TO GUSSET

- 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

FD 09/05/05 @

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:43 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47053

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

11:30

OVEN TEMPERATURE:

320°

FINISH TIME:

12:00

FL 09/05/05 (V)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



FL 09-05-5 (Q)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
20 Degree Cover Plate
batch: 341513



EP 09/05/06

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PB67-43001-83
batch: 347042



EP 09/05/06

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: M110704 (2x)



M111425 (8x)

EP 09/05/06

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: M111117



EP 09/05/06

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- match drill cover to existing holes in support
2- assemble as per dwg



EP 09/05/06 (V)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:43 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47053

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/06 @

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

09-05-06

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



MF 09-05-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

